

Work Order ID 50901

July 24, 2009 10:17:59 AM



Page 1

Item ID: D3957-3
Revision ID: A-PRELIM
Item Name: Hinge, Door LH Lower

Accept



Setup Start



Stop



Start Date: 24/07/2009 Start Qty: 2.00
Required Date: 29/07/2009 Req'd Qty: 2.00



PRELIMINARY ISSUE

Cust Item ID:
Customer:



Reference:

09-07-24

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3957	A-PRELIM								

100



Bandsaw

Jeaspa Bandsaw

Memo

cut blank to 3.200" long

0.00

0.00

mk 09/07/24

2

110



HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine as per Folio FA839

FOLIO REV: A

DWG REV: A

0.00

0.00

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER dWG

G. A 09/07/28

Work Order ID 50901

July 24, 2009 10:17:59 AM



Page 2

Item ID:	D3957-3	Accept		Setup	Start	
Revision ID:	A-PRELIM				Stop	
Item Name:	Hinge, Door LH Lower					
Start Date:	24/07/2009	Start Qty:	2.00		Cust Item ID:	
Required Date:	29/07/2009	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
			N.A	09/07/28		(2)			
130 QC Quality Control	QC8- Inspect parts - second check ENGINEERING APPROVAL Memo	0.00 0.00							
						(2)			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00							
			N/A	09/07-28					

[illegible]

Page 3

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. Finally, the fifth step is to evaluate the results of the project. This involves assessing whether the objectives have been met and identifying any lessons learned for future projects.

Setup Start

Stop

[illegible]**Cust Item ID:****Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

**Draw
Number**

**Draw
Rev.**

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

~~MASK~~ THREADED HOLE

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

remaining
on Eng. table

mf 09-07-29

Work Order ID 50901

July 24, 2009 10:17:59 AM



Page 4

Item ID:	D3957-3	Accept		Setup	Start	
Revision ID:	A-PRELIM				Stop	
Item Name:	Hinge, Door LH Lower					
Start Date:	24/07/2009	Start Qty:	2.00			
Required Date:	29/07/2009	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

chge to
R0309#JUL

~~POSITIVE RECALL~~
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

MF 09-07-29

Status	Item ID	Rev	Name	Quantity Per	UOM	Sort	Route Seq ID	Scrap %	Comments	Date Last Mod	Add Date
	M6061T6B0.750		6061-T6 Bar .750 x 4.00	0.266666	f		1 100	5 %		22/07/2009 1...	22/07/2009

[Handwritten signature]

M104741

.533"

QWL 09/07/24

DART AEROSPACE LTD		Work Order: 50902
Description: Hinge		Part Number: D3957-3
Inspection Dwg: D3957	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.56	+/- .030	0.560	✓			
1.25	+/- .030	1.257	✓			
1.93	+/- .030	1.931	✓			
0.12	+/- .030	0.150	✓			
0.125	+/- .010	0.127	✓			
0.094	+/- .010	0.095	✓			
3.00	+/- .030	2.998	✓			
0.69	+/- .030	0.685	✓			
0.281	+/- .010	0.281	✓			
0.281	+/- .010	0.281	✓			
0.33	+/- .030	0.325	✓			
0.39	+/- .030	0.385	✓			
0.585	+/- .010	0.585	✓			
1.170	+/- .010	1.171	✓			
Ø 0.257	+ .004 / - .001	Ø 0.259	✓			
Ø 0.063	+ .004 / - .001	Ø 0.064	✓			
0.250	+/- .030	0.243	✓			

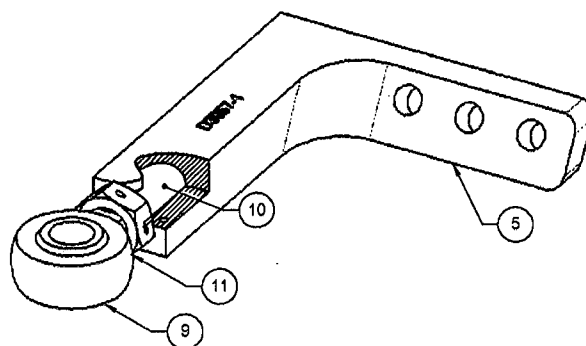
Measured by: K. A
Date: 09/07/28

Audited by: [Signature]
Date: 09.07.28

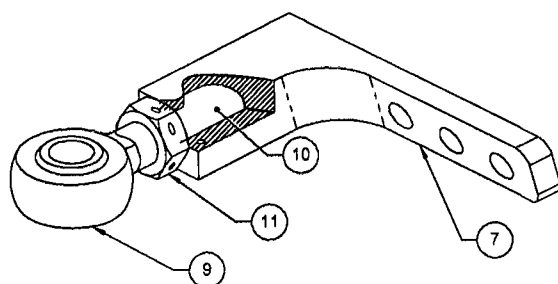
Prototype Approval: [Signature] N/A
Date: 09.07.28

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

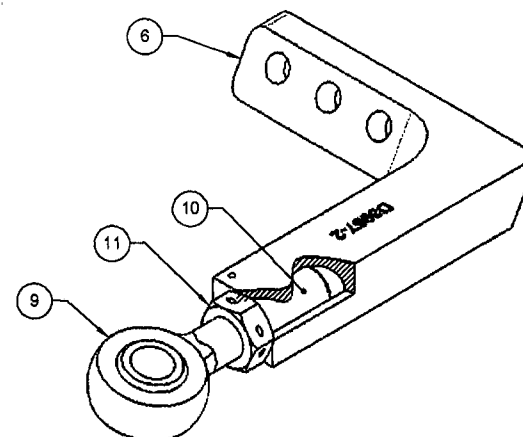
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2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3815-3	ROD END
10	1	1	1	1	MS124738	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



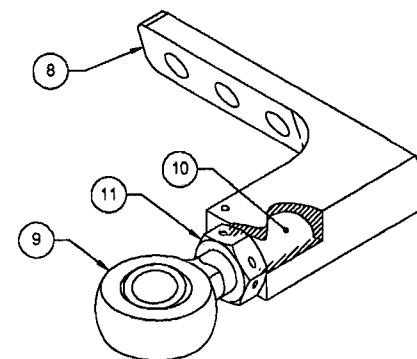
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

PRELIMINARY ISSUE

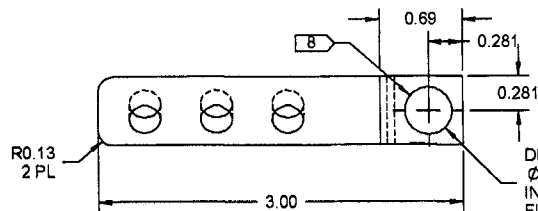
MP 29/10/04

A	NEW ISSUE	09.07.20
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.07.20	

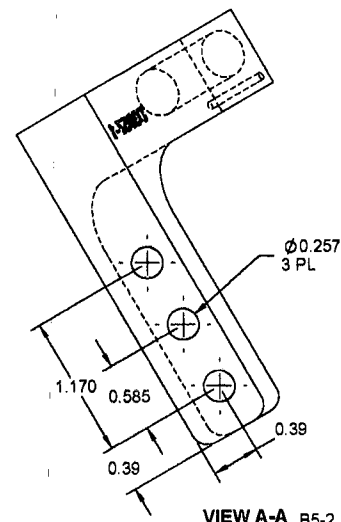
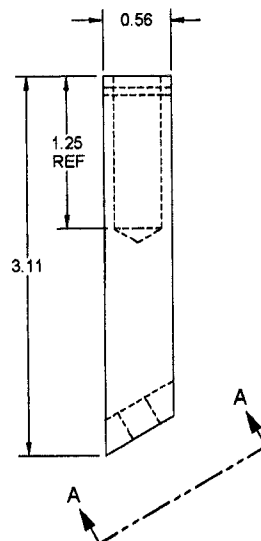
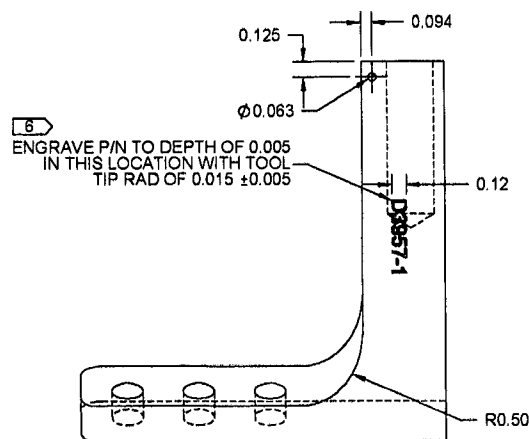
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3957** REV. A
SHEET 1 OF 5
TITLE **HINGE** SCALE NTS

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DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124738
 FLUSH WITH SURFACE



VIEW A-A B5-2

B B

120°

0.25

VIEW B-B C3-2

PRELIMINARY ISSUE
 Mr 09/11/04

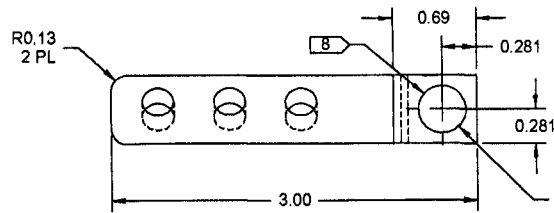
D3957-1 HINGE, DOOR LH UPPER

NOTES:

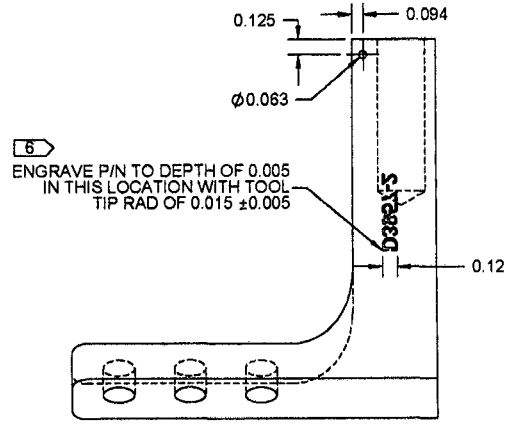
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.13 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	05	DART AEROSPACE LTD	
DRAWN	05	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PLH	DRAWING NO.	REV. A
MFG. APPR.	211	D3957	SHEET 2 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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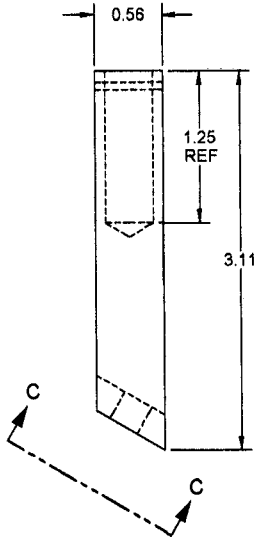
PRELIMINARY ISSUE
 NCR 10/14



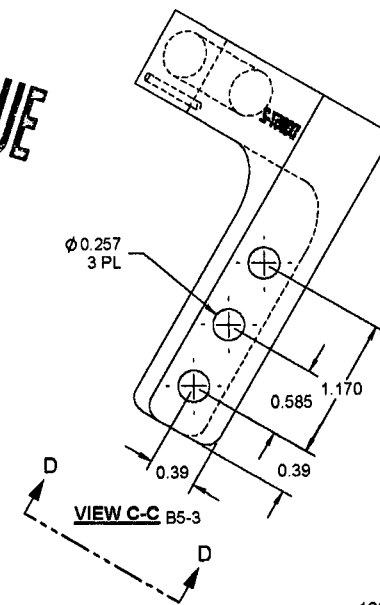
DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 Ø0.391 X 1.25 DP
 INSTALL HELICOIL MS124738
 FLUSH WITH SURFACE



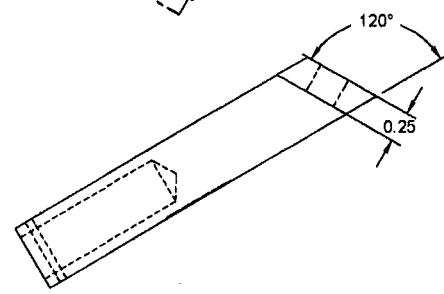
6
 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ±0.005



D3957-2 HINGE, DOOR RH UPPER



VIEW C-C B5-3

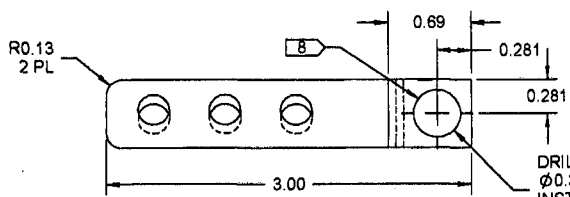


VIEW D-D C3-3

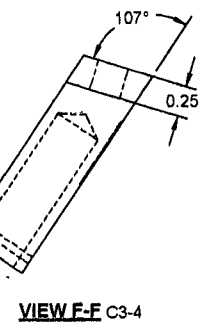
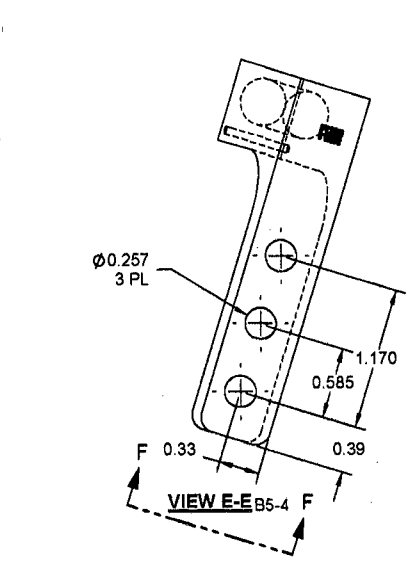
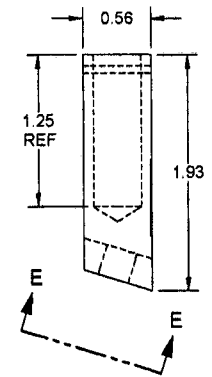
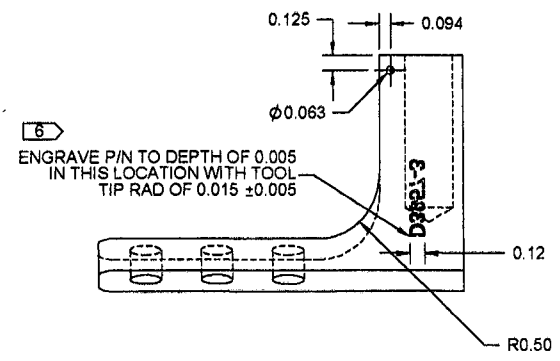
NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M8061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.13 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 3 OF 5
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DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124738
 FLUSH WITH SURFACE



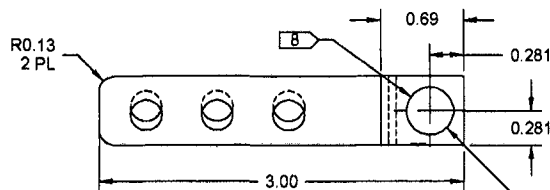
PRELIMINARY ISSUE
 WPA 9/10/14

D3957-3 HINGE, DOOR LH LOWER

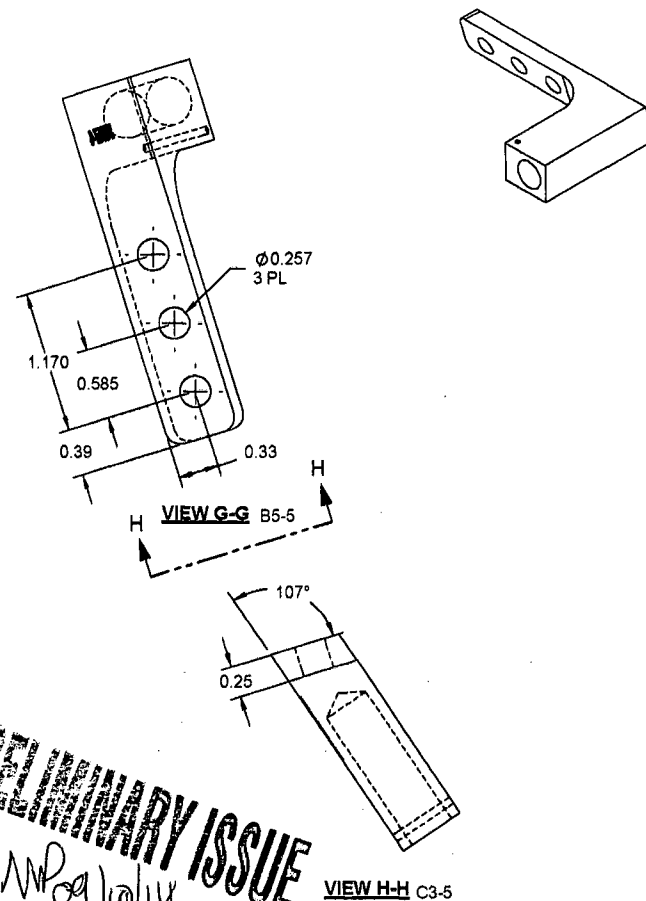
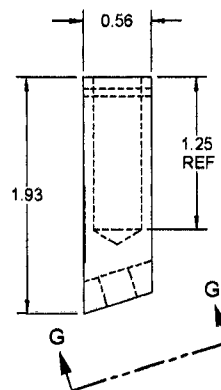
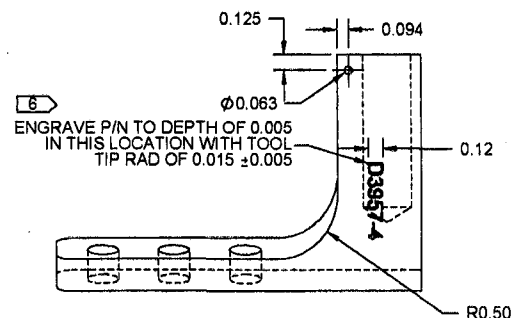
NOTES

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	15	DART AEROSPACE LTD	
DRAWN	15	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3957	SHEET 4 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124738
 FLUSH WITH SURFACE



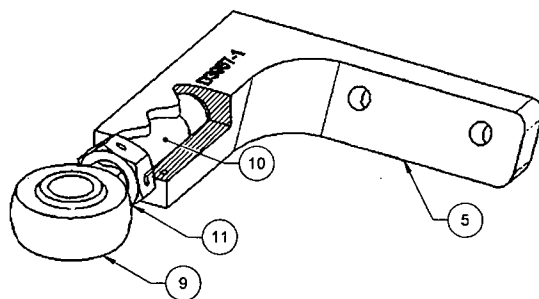
D3957-4 HINGE, DOOR RH LOWER

NOTES:

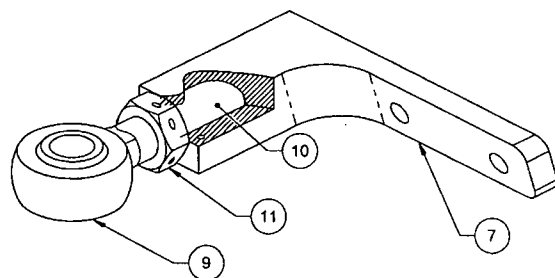
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 5 OF 5
APPROVED	AP	TITLE	SCALE
DE APPR.		HINGE	NTS
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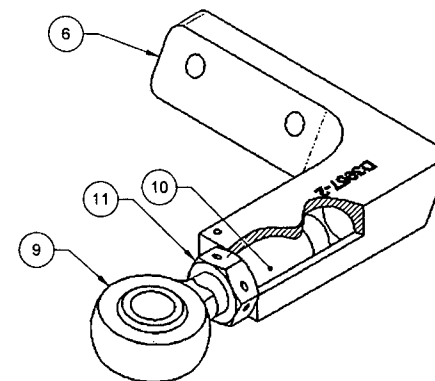
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



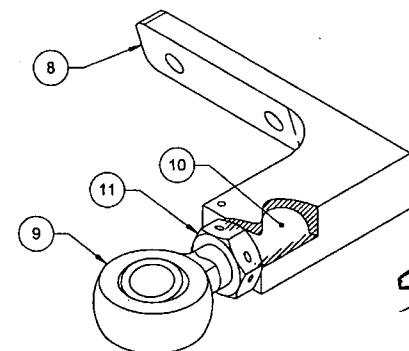
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



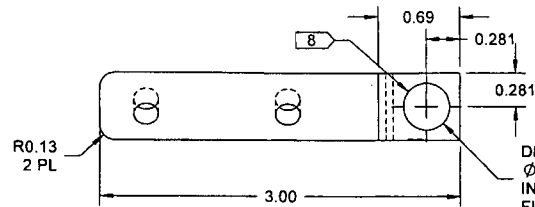
D3957-042 HINGE ASSY, DOOR RH UPPER



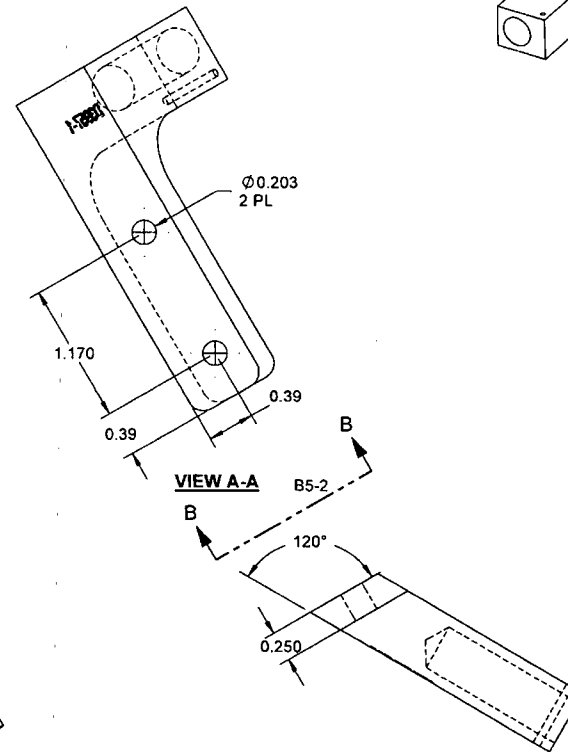
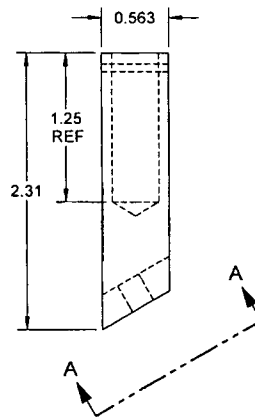
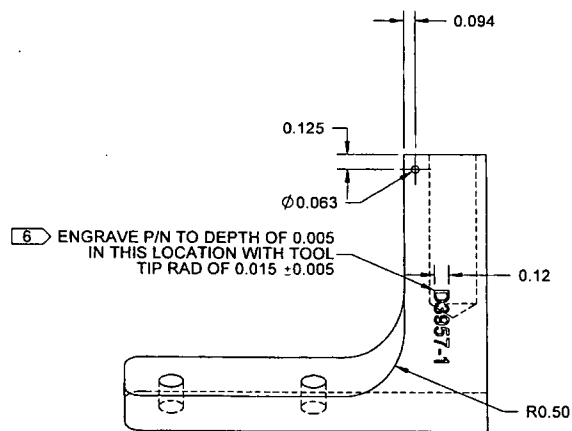
D3957-044 HINGE ASSY, DOOR RH LOWER

RELEASED
2009-10-08
JMD

A	NEW ISSUE	BY	09.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3957	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		HINGE	NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.09.03		



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



VIEW A-A

VIEW B-B

50901

C3-2
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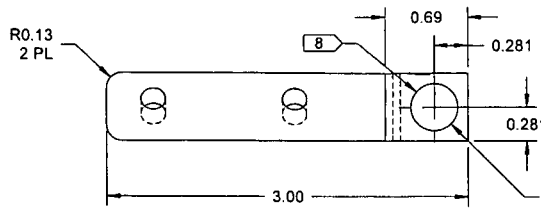
D3957-1 HINGE, DOOR LH UPPER

NOTES:

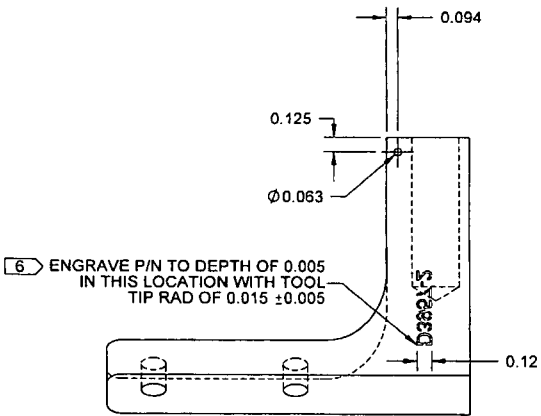
- 1) MATERIAL: 6061-T6 (6061-T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	<i>AE</i>	DART AEROSPACE LTD	
DRAWN	<i>AE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3957	SHEET 2 OF 5
APPROVED	<i>AE</i>	TITLE	SCALE
DE APPR.	<i>AE</i>	HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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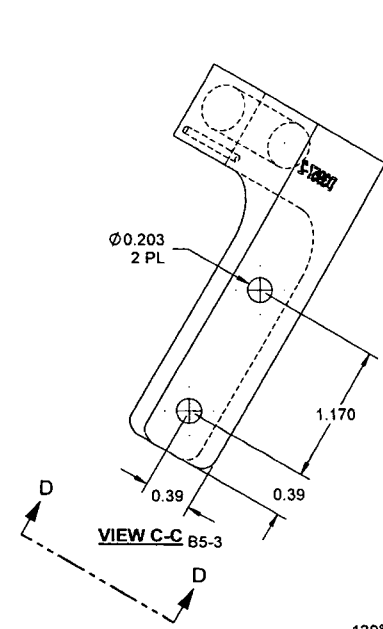
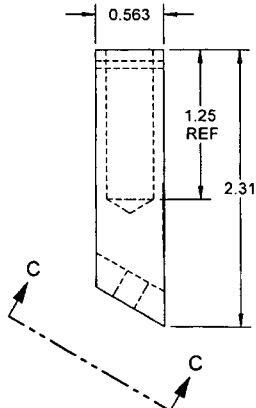
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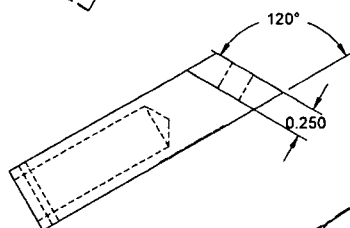
DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 \pm 0.005



VIEW C-C



VIEW D-D

C3-3

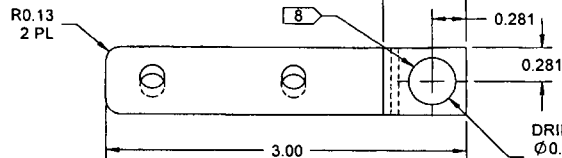
D3957-2 HINGE, DOOR RH UPPER

- NOTES:
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
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 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
 - 7) WEIGHT: 0.10 lbs
 - 8) MASK HOLE PRIOR TO POWDER COAT

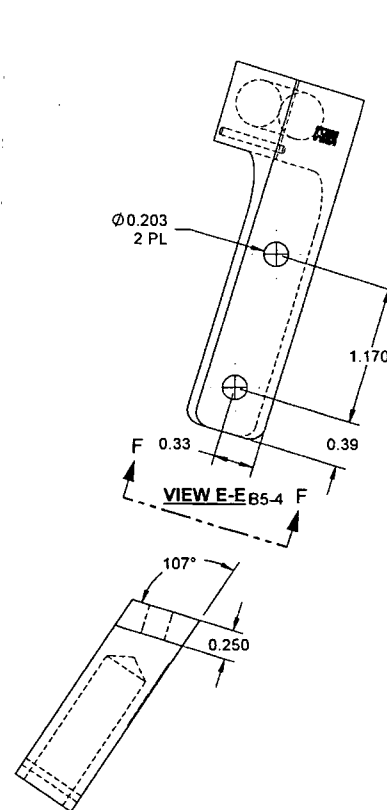
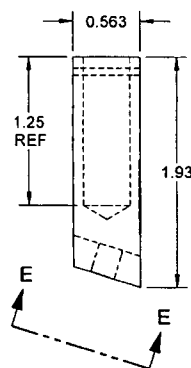
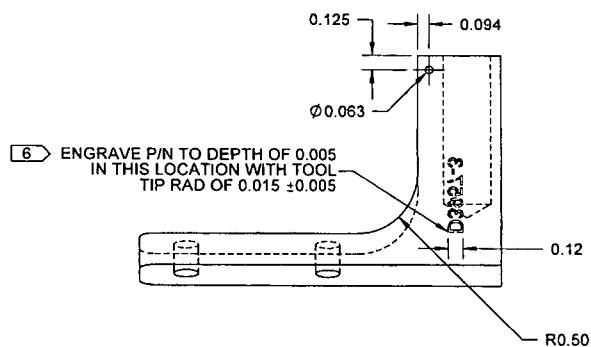
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3957	SHEET 3 OF 5
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DE APPR.		HINGE	NTS
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8 7 6 5 4 3 2 1



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE









VIEW F-F C3-4

D3957-3 HINGE, DOOR LH LOWER

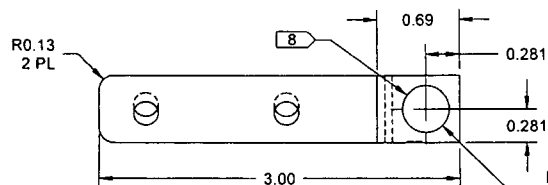
NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

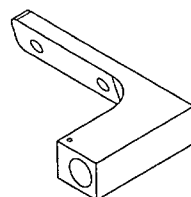
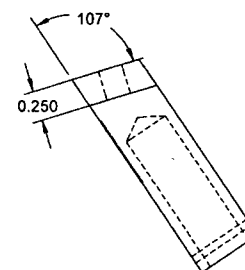
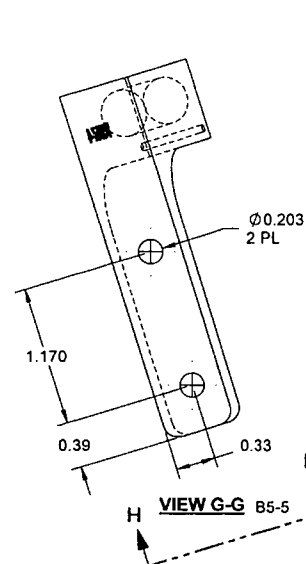
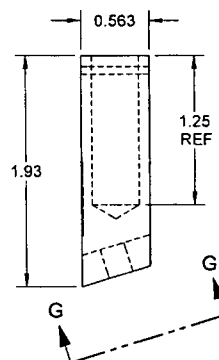
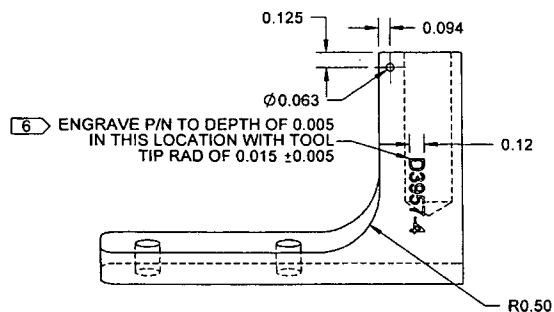
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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 2009-10-08
 mdp

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DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



D3957-4 HINGE, DOOR RH LOWER

NOTES:

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 5 OF 5
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